

Date: Wednesday, 3/14/2007 3:31:11 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: EXTRUSION "I" BEAM WEB 4"		
Job Number	: 31223			Part Number	: D25003100	
Estimate Number	: 10155			Drawing Number	: D2500 REV F1	
P.O. Number	: N/A			Project Number	: N/A	
This Issue	: 3/14/2007		S.O. No.	: N/A		
Prsh Rev.	: NC			Drawing Revision	: F1	
First Issue	: 3/14/2007		Type	: PURCHASED PARTS		
Previous Run	: 25751			Material	: N/A	
Written By	:			Due Date	: 4/6/2007	
Checked & Approved By	:			Qty:	167 Um: 90 Each	
Comment	: Est: E 92.09.10 Added DSK 066 KJ					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		<b>Comment:</b> PURCHASING Issue P/O: <u>3318</u> <span style="margin-left: 100px;"><i>C\07/03/15</i></span> <u>1627</u> a) Extrude as per Dwg D2500 b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation = 10% f) Order at 100" long g) Caradon Indalex Tool # MS-18867 h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required
2.0	D25003100P	Ext'n - I' Beam Web 4"
		<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 90.0000 Each(s) EXTRUSION "I" BEAM WEB 4"
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		<b>Comment:</b> PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached <i>D07/04/05 (115)</i>
4.0	QC6	DIMENSIONAL CHECK
		 <i>0705.14</i> <span style="border: 1px solid black; border-radius: 50%; padding: 5px; display: inline-block;">115</span>
		<b>Comment:</b> DIMENSIONAL CHECK Inspect dimensions per Dwg D2500 Check Pull test per Dwg D2500 for compliance page attached.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/05/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 3:31:12 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EXTRUSION 'I' BEAM WEB 4"

Job Number: 31223

Part Number: D25003100

Job Number:



Seq. #:

Machine Or Operation:

Description :

Check hardness with Webster tester

5.0 PACKAGING 1

PACKAGING RESOURCE #1



(115)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

JD 7-5-23

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

JD 07/

Job Completion



U 07.05.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>DKY</i>	DRAWN BY <i>DKY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>DKY</i>	DRAWING NO. D2500	REV. F SHEET 1 OF 2
DATE 97:09:29		TITLE EXTRUSION	SCALE NTS
A	96:03:19	NEW ISSUE	
B	96:03:24	CHANGE INTERNAL WEB	
C	96:04:26	ADD D2500-3 WEB	
D	96:10:07	ADD MATERIAL PROPERTIES	
E	96:10:24	CHANGE MATERIAL TEMPER	
F	97:09:29	CHANGE MAT. TO 6061-T6	
F1	01.04.17	ADD NOTES 4&5 <i># CP</i>	

**RELEASED**  
*(97/09/06 DS)*

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM TENSILE YIELD STRENGTH = 35 ksi  
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi  
 MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX

3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

4. FOR D2500-1, PART NUMBER IS D2500-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2500-1-190 IS 190" LONG)

D2500-1 EXTRUSION MANUFACTURED FROM: a) BON L DIE # B97105 → PREFERRED  
 b) CARBON MIDAST DIE # PAH-28030  
 c) CARBON MTL DIE # MH-18868

5. FOR D2500-3, PART NUMBER IS D2500-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2500-3-100 IS 100" LONG)

D2500-3 EXTRUSION MANUFACTURED FROM CARBON INDIA DIE # MS-18867

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 31223

DR CO  
ISSUED BY



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	VICTORIA INTERNATIONAL AIRPORT, CANADA
DATE		D2500
97.09.29		TITLE
		EXTRUSION

REV. F

SHEET 2 OF 2

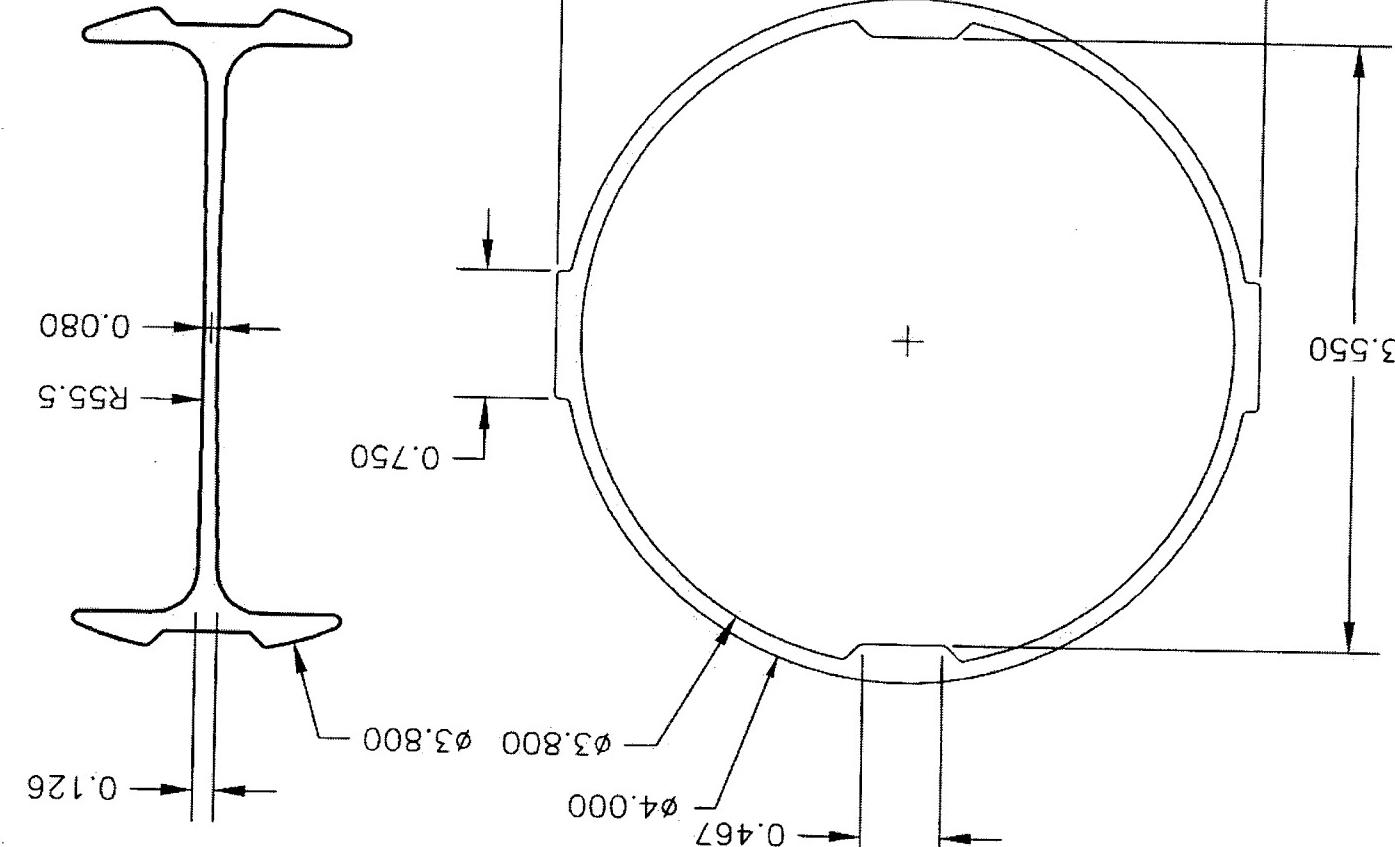
SCALE

1:1

RELEASED  
47/10/96 DS

D2500-3

D2500-1



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31223

Copyright 1996/1997 by DART AEROSPACE LTD

